

Monday, 12/17/2007 1:03:25 PM

User: Kim Johnston

Process Sheet

52

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
 Job Number : 36374
 Estimate Number : 10553
 P.O. Number :
 This Issue : 12/17/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D206667103
 First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D206-667-143 REV B
 Previous Run : 36055 Drawing Revision : B
 Material :
 Due Date : 12/24/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JA 07.12.17
 Comment : Est Rev E 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



KJ 07.12.19

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

2/5086104

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115

Crosstube

B23966

Check OD = 2.250"; ID = 1.750"

J.F. 07/12/21 ①

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

J.F. 07/12/21 ①

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/17/2007 1:03:25 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/21 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/21 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/02 ②

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

AWM 08-01-04

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 8-1-4

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 08-01-04

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 8-1-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5434 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 8/01/14 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CL 8/01/11 ①

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

CL 08/01/11 ①

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

BT 08-01-13

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

BT 08/01/14

①

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip 35900

BT 08-01-16

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 36064

BT 08-02-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 12/17/2007 1:03:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

34077

RT 08-02-01

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34062

RT 08-01-16

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

105057

RT 08-02-01

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

103478

RT 08-01-16

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

} RT 08-01-16

RT 08-02-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



08-02-04 @



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M105408*

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: *M105940*

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt *M106167*

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt *M105144*

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer *M106167*

fc 8/2/04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36374

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/08/2/04 (1)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: B

PPP Rev: 8/12/4

500 (1)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/08/02/06 (1)

Job Completion



2008/2/05 (1)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36374
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

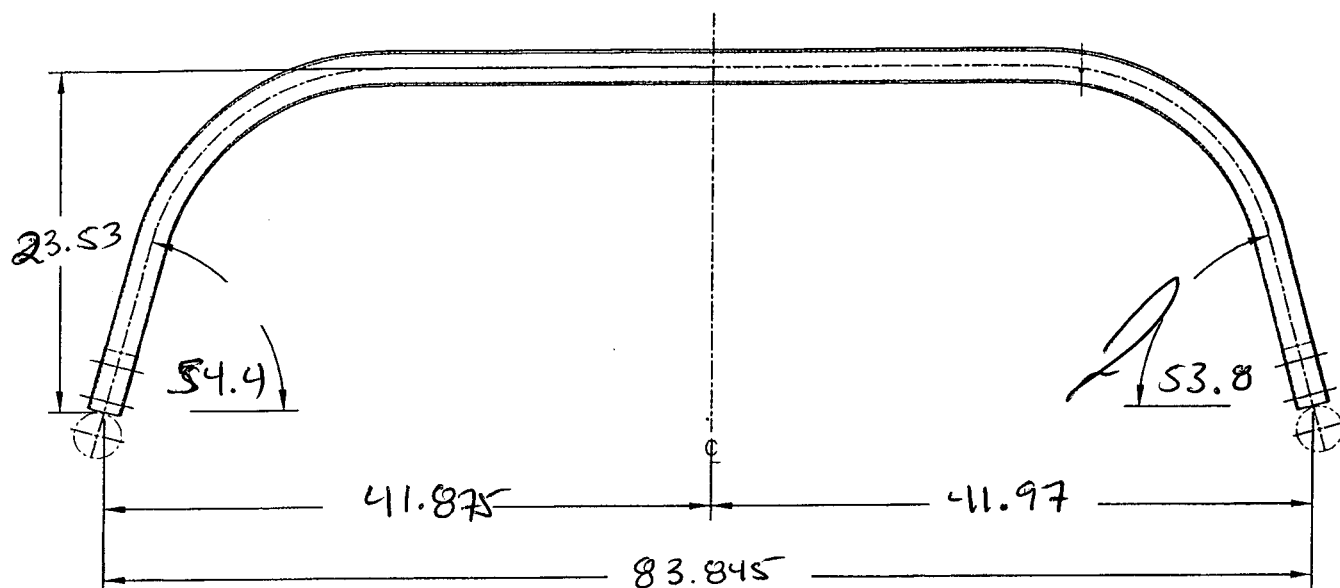
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244"	✓			
	1.982	+0.005/-0.000	1.986"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.062"	✓			
	2.097	+0.005/-0.000	2.100"	✓			
	2.136	+0.005/-0.000	2.138"	✓			
	2.176	+0.005/-0.000	2.180"	✓			
	2.201	+0.005/-0.000	2.204"	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.434"	✓			
SIDE B	104.98	+/-0.020	104.960"	✓			
	2.240	+0.005/-0.000	2.244"	✓			
	1.982	+0.005/-0.000	1.987"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.063"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.138"	✓			
	2.176	+0.005/-0.000	2.179"	✓			
	2.201	+0.005/-0.000	2.204"	✓			
	0.125	+/-0.010	.125"	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.435"	✓			

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 07/12/21	Date: 08/01/22	Date:	N/A

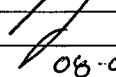
Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	


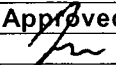
DART AEROSPACE LTD		Work Order:	36374
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	 06-01-07
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM 	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26 H

UNDER REVIEW

05.07.10 PH

re-draw detail F
PH

07.05.02

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

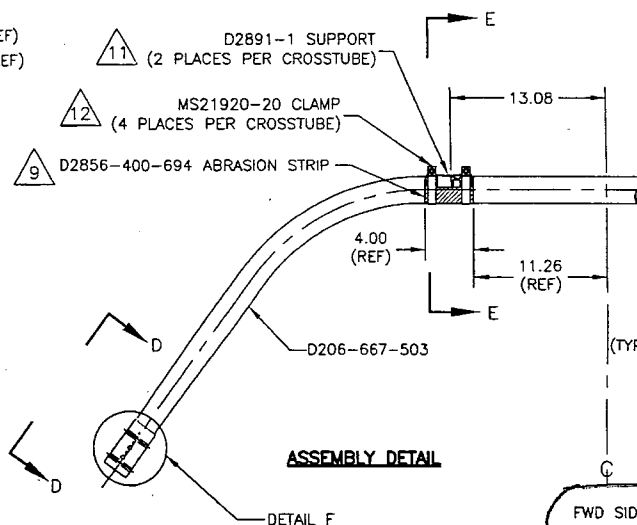
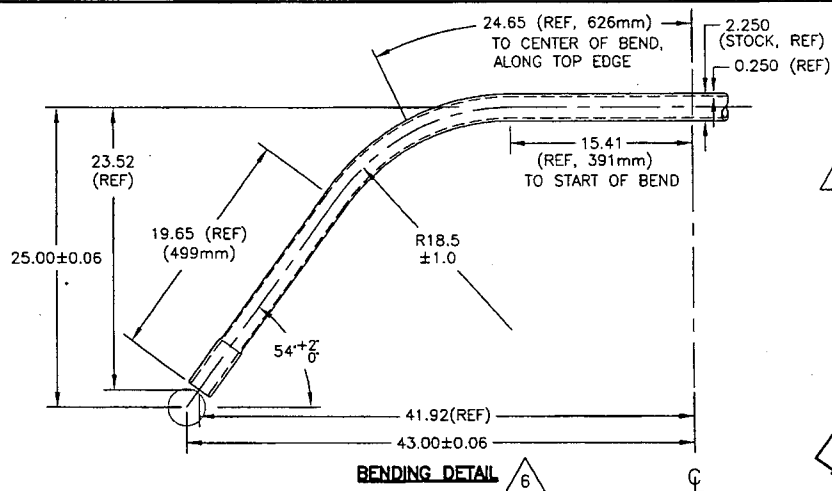
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBES. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36374

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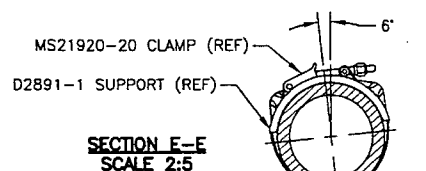
B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

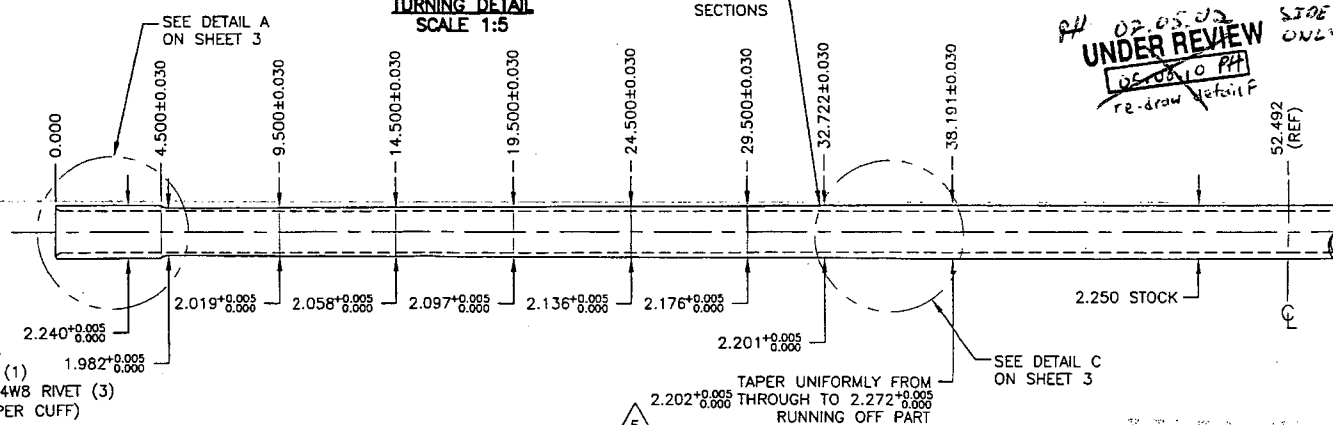
DETAIL F
SCALE 2:5

FWD SIDE ONLY



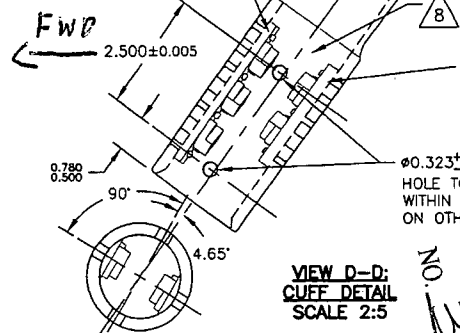
TURNING DETAIL
SCALE 1:5

R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS



D2856-400-694 ABRASION STRIP (REF)

D2873-043 NUT PLATE (1)
MS20601AD4W8 RIVET (4)
(1 PLACE PER CUFF)



D2873-045 NUT PLATE (1)
MS20601AD4W8 RIVET (3)
(1 PLACE PER CUFF)

NO. 30374
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

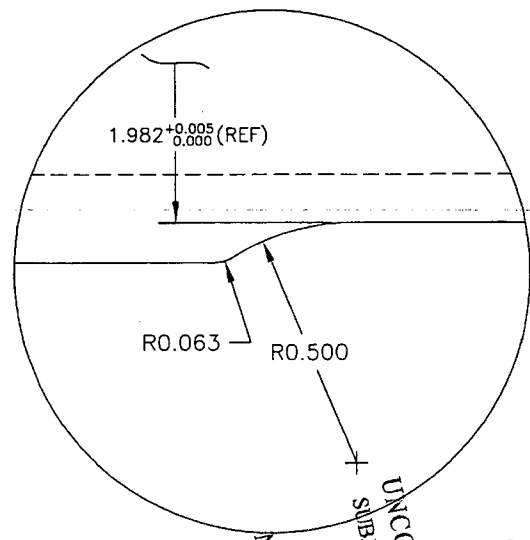
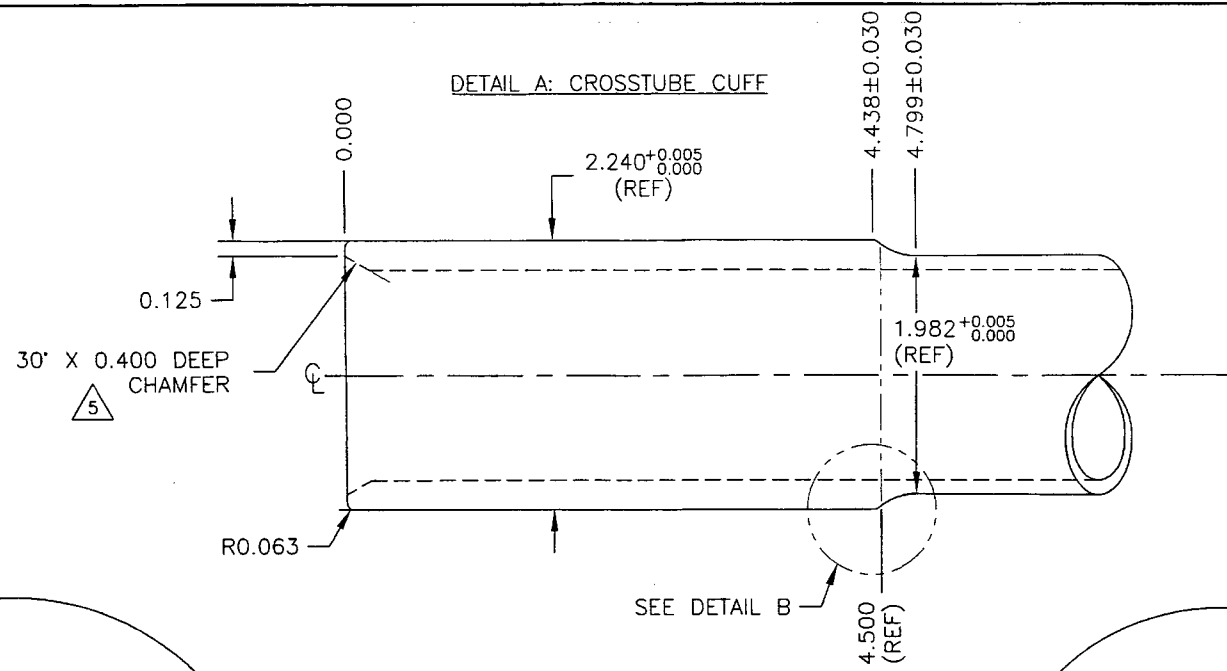
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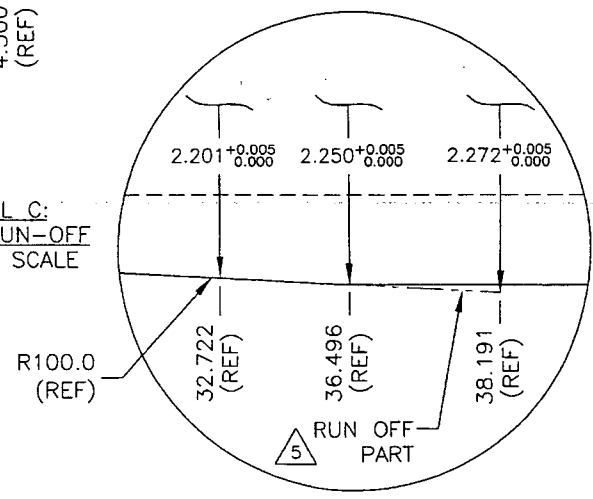
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CHECKED DS	APPROVED DS	DRAWING NO. D206-667-143	SHEET 2 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10	

05.07.26 PH

UNDER REVIEW
06.03.26 PH
REVIEW DETAIL F
PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1



DETAIL C:
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DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)		SCALE 1:1	



LIQUID PENETRANT TEST REPORT

P - 8-1206

PAGE 1 OF 1
TIME AM ☐ PM ☐

CLIENT DART AREOSPACE DATE JAN. 11, 2008
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-8-01206
ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT. POWO No.
WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417/QSI-038 REV./DATE 2005
PROJECT HIGH AFT X-TUBE 412, 206B AFT X-TUBE, 206L FWD X-TUBE, 206L AFT X-TUBE
ITEM(S) EXAMINED JOBS #36061, 36062, 36371, 36372, 36374, 36375, 36376, 36378, 36380, 36382

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-0002-02 REV./DATE
Part No. D206667201, D206667103, D412664203, D206667203 Material ALODYNED ALUMINUM Thickness
Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

Method ☒ Fluorescent ☐ Visible ☒ Water Wash ☐ Solvent Removable ☐ Post Emulsified
Family Brand MAGNAFLUX Black Light S/N 8178 ☒ Output > 1000 μ W/cm² ☒ Ambient < 2 fc
Penetrant ZL67 Minimum Dwell time 45 Min. Lighting Equip. ☒ Flashlight ☐ Troublelight ☒ Output > 100 fc @ surface
Penetrant Remover H2O Minimum Dry time > 10 Min. Other
Developer SKDS2 Minimum Dwell time 10 Min. Light Meter S/N Cal Due Date MAR 08
Developer Type ☒ Non Aqueous ☐ Aqueous ☐ Dry

TEST SURFACE

Surface Condition ☒ As Ground ☐ As Welded ☒ Machined ☐ Shot Blasted ☐ Clean Bare Metal
Surface Temperature ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F to 10°C/50°F ☒ 10°C/50°F to 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

item	Comments	Accept	Reject
Job #	36061: ACCEPTABLE		
	36062: ACCEPTABLE		
	36371: ACCEPTABLE		
	36372: ACCEPTABLE		
	36374: ACCEPTABLE		
	36375: ACCEPTABLE		
	36376: ACCEPTABLE		
	36378: ACCEPTABLE		
	36380: ACCEPTABLE		
	36382: ACCEPTABLE		

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative *Eric Downing* DTR #
Technician (Signature): *Frederick Chagnon* signature
Name (Print): FREDERICK CHAGNON
CGSB Level II 1st technician CGSB Level 2nd technician
CGSB Reg. No 10560 CGSB Reg. No

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